

Date: Thursday, 7/19/2007 2:27:58 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: SPACER
Job Number	: 33676		
Estimate Number	: 12953		
P.O. Number	: N/A	Part Number	: D32595
This Issue	: 7/19/2007	S.O. No.	: N/A
Prsht Rev.	: NC	Drawing Number	: D3259 REV A1
First Issue	: N/A	Project Number	: N/A
Previous Run	: N/A	Drawing Revision	: A1
Written By	:	Material	: N/A
Checked & Approved By	: <i>HB 07-07-19</i>		
Comment	Est RevA	New Issue 07-07-19	JLM
		Verified By:	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M2024T3S032	2024-T3 .032 sheet
	Comment: Qty.: 1.4574 sf(s)/Unit Total : 5.8296 sf(s) 2024-T3 .032 sheet Batch: <i>M102-942</i>	<i>HB 07-07-26</i>
2.0	WATER JET	FLOW WATER JET
	Comment: FLOW WATER JET 1-Cut as per Dwg D3259 Dwg Rev: <i>A1</i> Prog Rev: <i>A1</i>	<i>HB 07-07-26</i>
	2-Deburr if necessary	<i>540 07/07/26</i>
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
		<i>HB 07-07-26</i>
	Comment: INSPECT PARTS AS THEY COME OFF MACHINE	
4.0	QC8	SECOND CHECK
		<i>x4 wanted</i>
	Comment: SECOND CHECK	
5.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
		<i>HB 07-07-31</i>
	Comment: HAND FINISHING RESOURCE #1 Chemical Conversion Coat as per QSI 005 4.1	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: D Date: 07/08/01
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 7/19/2007 2:27:58 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SPACER

Job Number: 33676

Part Number: D32595

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

7.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

ESo7/08/01 QV



8.0 QC21

FINAL INSPECTION/W/O RELEASE



(4)

Comment: FINAL INSPECTION/W/O RELEASE

SD7/08/01

Job Completion



JUL 07.08.01

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

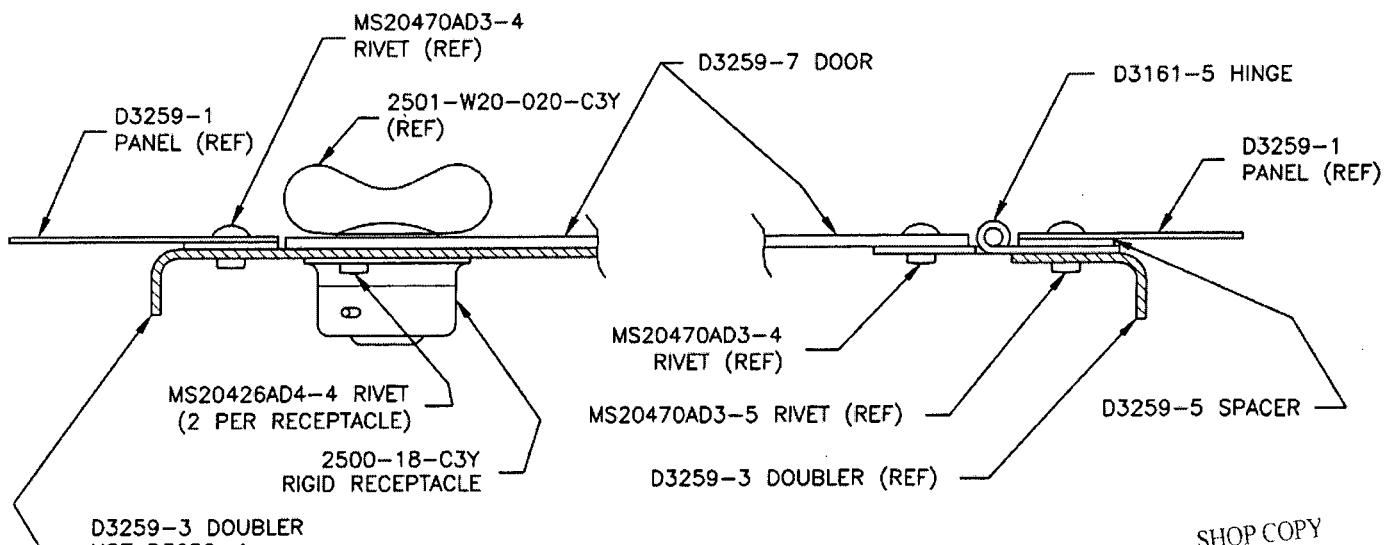
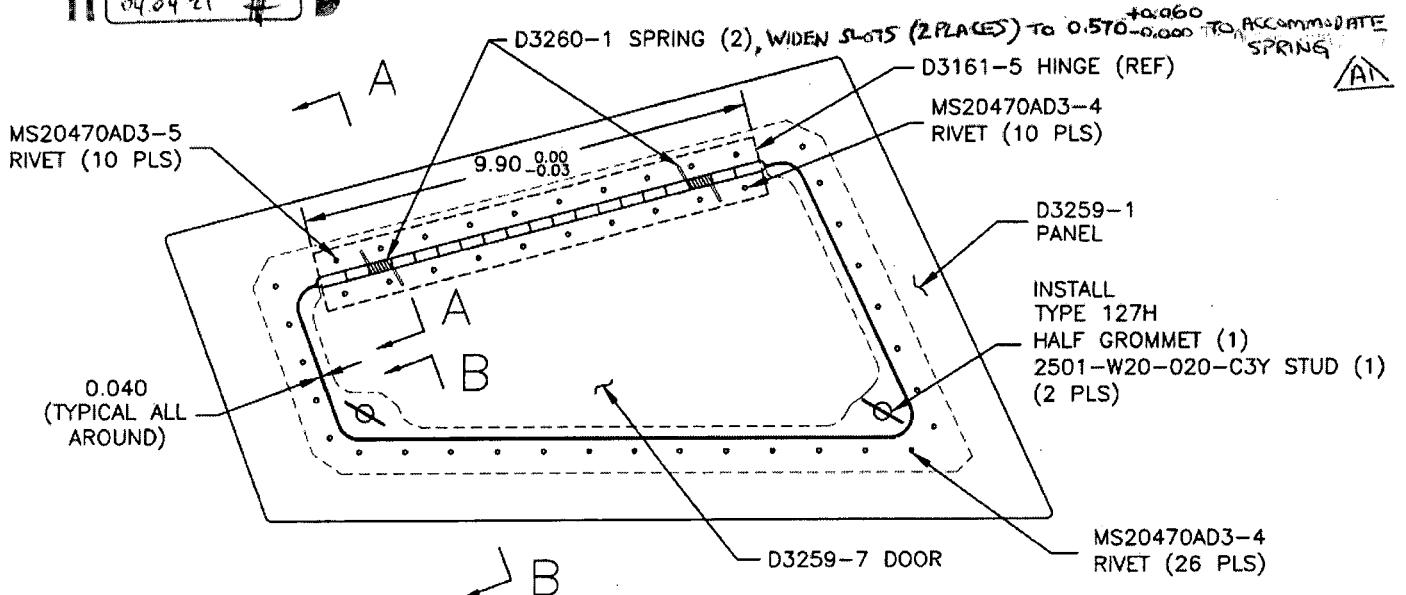
NOTE: Date & initial all entries

DARTCOPY ISSUE
DRAFT

DESIGN RF	DRAWN BY <i>IP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>IP</i>	APPROVED <i>IP</i>	DRAWING NO. D3259	REV. A SHEET 1 OF 6
DATE 04.02.25		TITLE ACCESS PANEL ASSEMBLY	SCALE 1:14
A	04.02.25	NEW ISSUE	
A1	<i>IP</i> 04.08.11	WIDEN SLOTS TO ALLOW OPERATION OF SPRING	

RELEASED

04.04.21


SECTION B-B
VIEW ROTATED

D3259-041 ACCESS PANEL ASSEMBLY (SHOWN)
D3259-042 ACCESS PANEL ASSEMBLY (OPPOSITE)

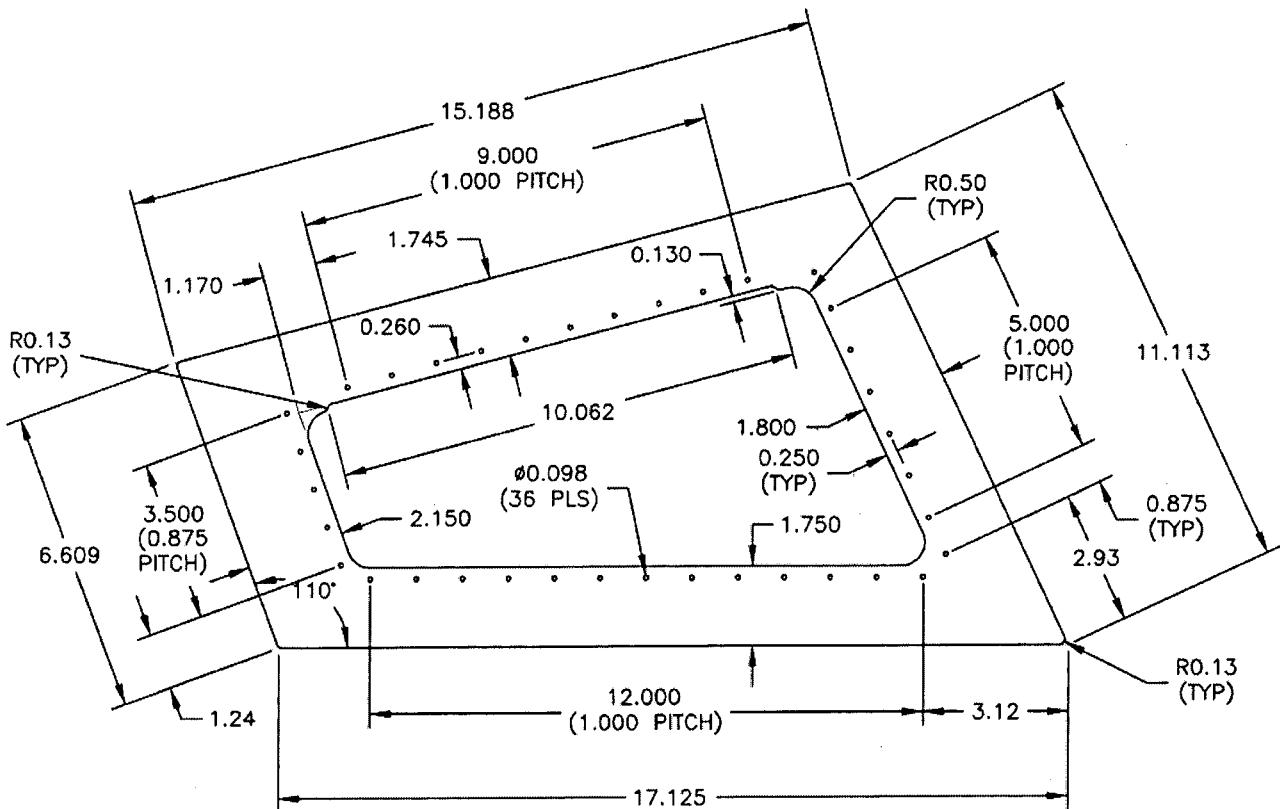
- 1) ASSEMBLE IN ACCORDANCE WITH DART QSI 002
- 2) IDENTIFY WITH P/N & B/N USING FINE POINT PERMANENT MARKER

SECTION A-A
VIEW ROTATED

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DART

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CHECKED <i>TT</i>	APPROVED <i>TT</i>	DRAWING NO. D3259	REV. A SHEET 2 OF 6
DATE 04.02.25		TITLE ACCESS PANEL ASSEMBLY	SCALE 1:4

RELEASED
04.04.05
**D3259-1 PANEL****NOTES:**

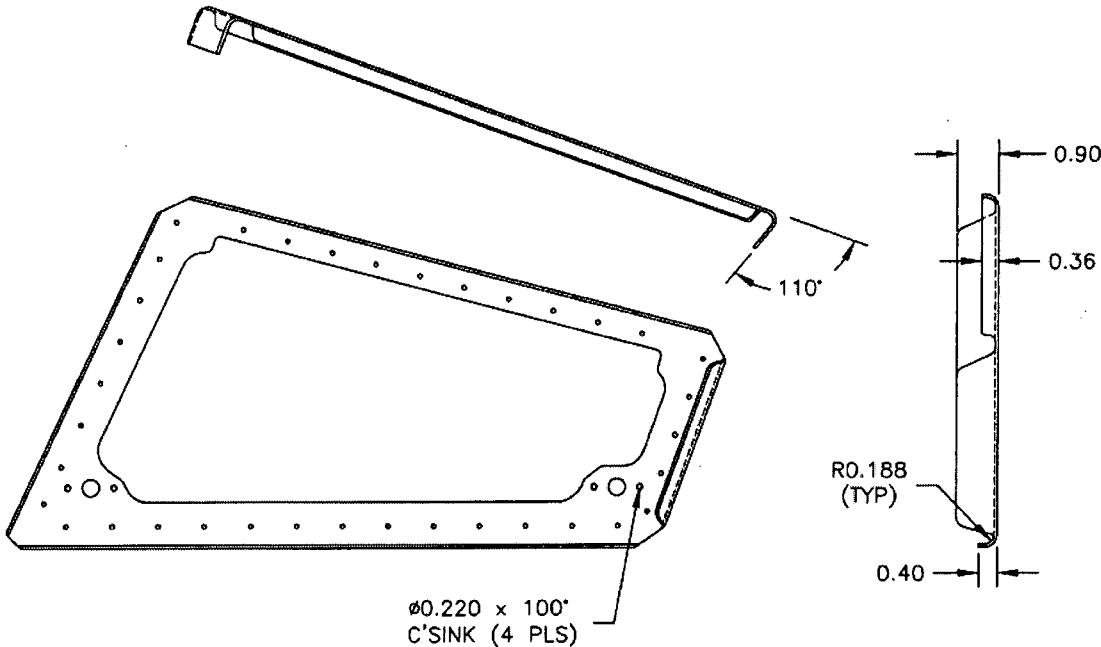
- 1) MATERIAL: 2024-T3 (QQ-A-250/4) 0.032 THICK (M2024T3S.032)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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CHECKED <i>HF</i>	APPROVED <i>HF</i>	DRAWING NO. D3259	REV. A SHEET 3 OF 6
DATE 04.02.25		TITLE ACCESS PANEL ASSEMBLY	SCALE 1:4

RELEASED
04.04.14



D3259-3 DOUBLER BEND DETAIL (SHOWN)

BEND D3259-4 DOUBLER (OPPOSITE)

D3259-3/-4 NOTES:

- 1) MANUFACTURE PER "D2359-A4.DWG"
- 2) MATERIAL: 2024-T3 (QQ-A-250/4) 0.063 THICK (M2024T3S.063)
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

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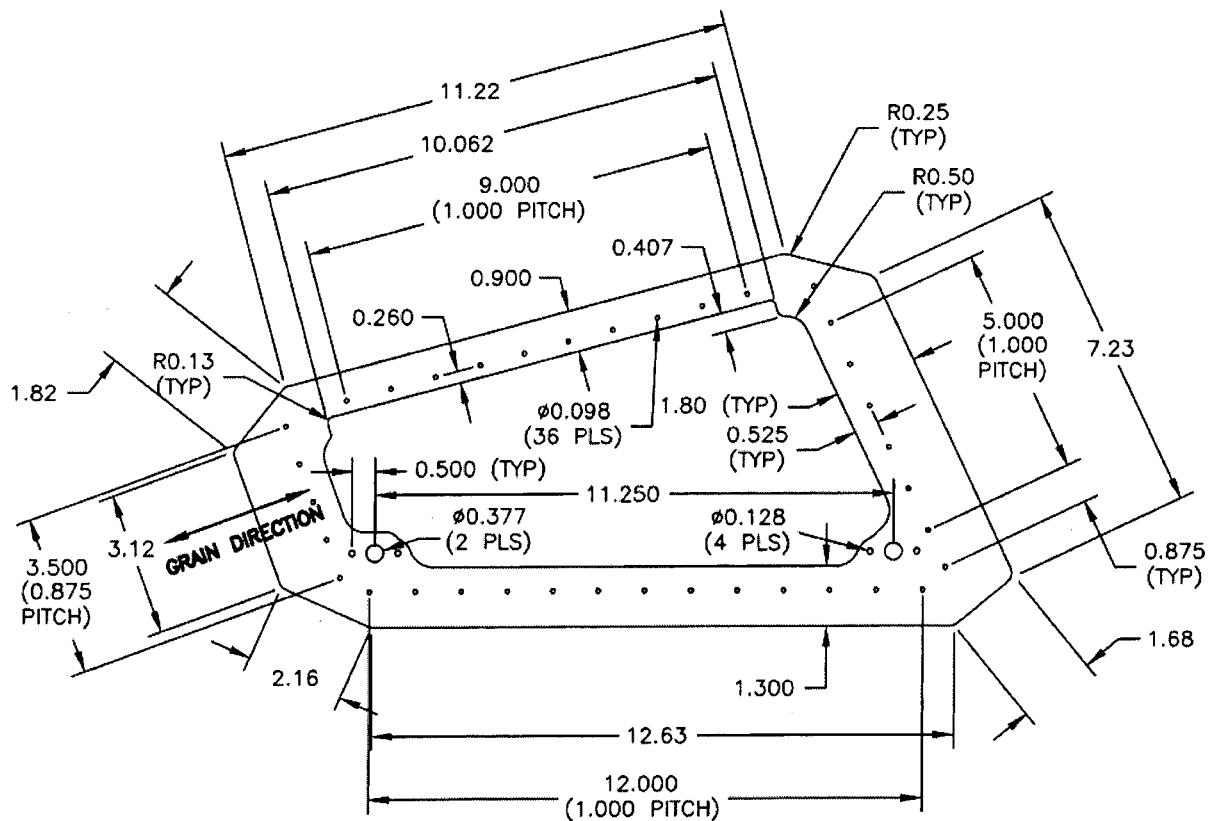
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CHECKED	APPROVED	DRAWING NO. D3259
DATE 04.02.25		REV. A SHEET 4 OF 6 TITLE SCALE 1:4 ACCESS PANEL ASSEMBLY

RELEASED

04 04.14 04



D3259-3/-4 DOUBLER FLAT PATTERN
(Ø0.098 HOLES TO COINCIDE WITH HOLES IN D3259-1)

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NO 33676

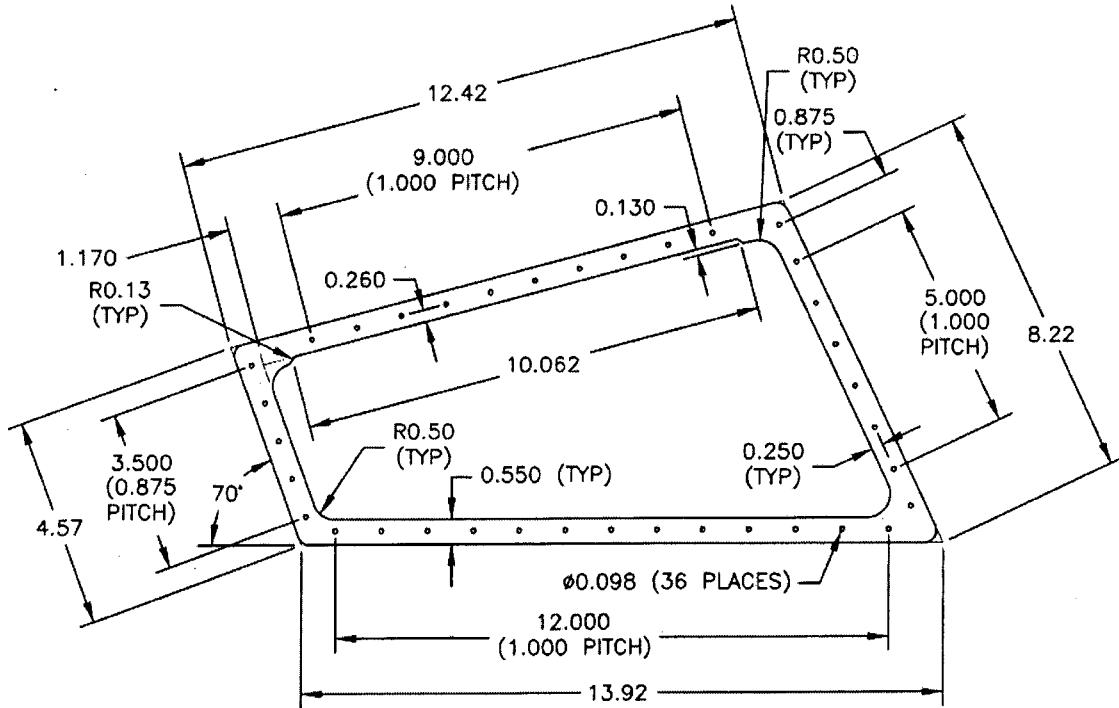
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CHECKED <i>#</i>	APPROVED <i>#</i>	DRAWING NO. D3259	REV. A SHEET 5 OF 6
DATE 04.02.25	TITLE ACCESS PANEL ASSEMBLY		SCALE 1:4

RELEASER
04-07-05 DR



D3259-5 SPACER

(#0.098 HOLES TO COINCIDE WITH HOLES IN D3259-1)

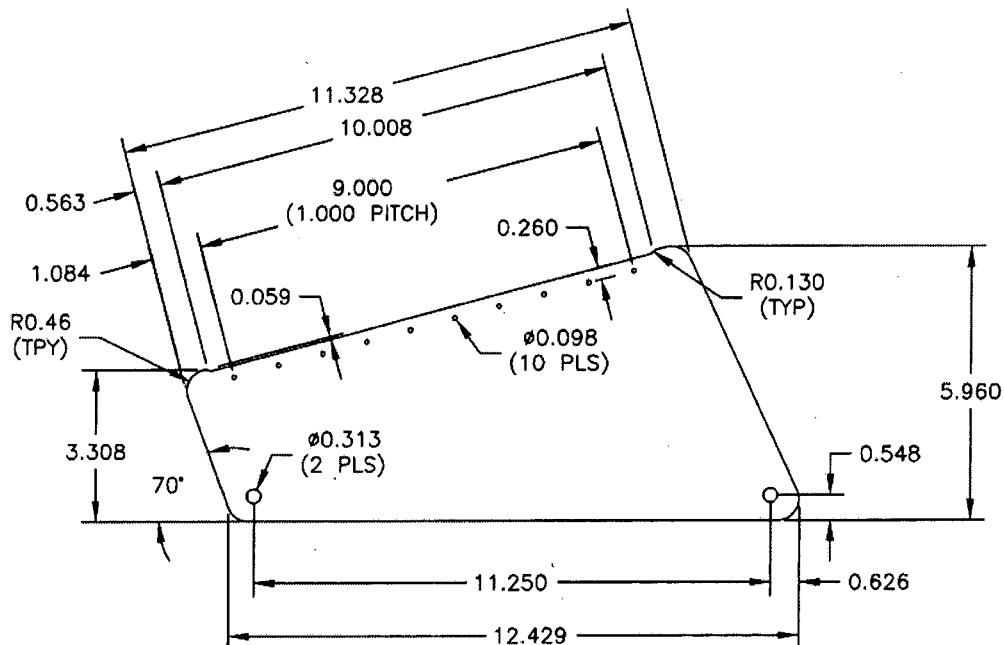
NOTES:

- 1) MANUFACTURE PER "D3259-A5.DWG"
- 2) MATERIAL: 2024-T3 (QQ-A-250/4) 0.032
- 3) FINISH: CHEMICAL CONVERSION COAT PER
- 4) TOLERANCES ARE PER DART QSI 018 UNL
- 5) ALL DIMENSIONS ARE INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3259	REV. A SHEET 6 OF 6
DATE 04.02.25		TITLE ACCESS PANEL ASSEMBLY	SCALE 1:4

RELEASED
 04.04.14 *[Signature]*
**D3259-7 DOOR****NOTES:**

- 1) MANUFACTURE PER "D3259-A6.DWG"
- 2) MATERIAL: 2024-T3 (QQ-A-250/4) 0.063 THICK (M2024T3S.063)
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

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DART AEROSPACE LTD	Work Order:	33676
Description: SPACER	Part Number:	J 3259-5
Inspection Dwg:	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by: <u>IB</u>	Audited by: <u>EP</u>	Prototype Approval: <u>KF9</u>
Date: <u>07-07-26</u>	Date: <u>07/07/26</u>	Date: <u>07/07/26</u>

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	